

Date: Monday, 19/01/2009 2:05:44 PM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: DOUBLER
Job Number	: 44889		
Estimate Number	: 10227		
P.O. Number	:	Part Number	: D2151
This Issue	: 19/01/2009	S.O. No.	:
Prsht Rev.	: NC	Drawing Number	: D2151 REV B
First Issue	: / /	Project Number	: N/A
Previous Run	: 36844	Drawing Revision	: B
	Type	Material	:
	: SMALL /MED FAB	Due Date	: 10/02/2009
Written By	:	Qty:	40
		Um:	Each
Checked & Approved By	: <u>JLD 09.01.20</u>		
Comment	: Est C 00.10.23 Re-format (mpp 2101) EC Est Rev:D 06-04-28 Manufactured on Water Jet JLM Est Rev:E 06-11-24 As per Rev B JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M2024T3S040	2024-T3 .040 sheet
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Comment: Qty.: 0.0368 sf(s)/Unit Total : 1.4700 sf(s)
 Material: 2024-T3 (QQ-A-250/4) 0.040" thick
 (M2024T3S.040) Batch: 107572 18 9-2-17

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
 1-Cut as per Dwg D2151
 Dwg Rev: B
 Prog Rev: B

18 9-2-17

2-Deburr if necessary

M. J

09/02/17

(45)

(45X)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

18 9-2-17

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

09-02-18 (45)
counted

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1
 Deburr N/A

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Seq. #: Machine Or Operation: Description :

6.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1
Chemical Conversion Coat as per QSI 005 4.1

BR 09-02-18

45

7.0 POWDER COATING POWDER COATING



Comment: POWDER COATING
Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

1A109996

START TIME: 2:20pm
OVEN TEMPERATURE: 320°F
FINISH TIME: 2:50pm

09-02-18

45

8.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

FX 09/02/18

45

9.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: _____

09/2/18

45

10.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/02/20

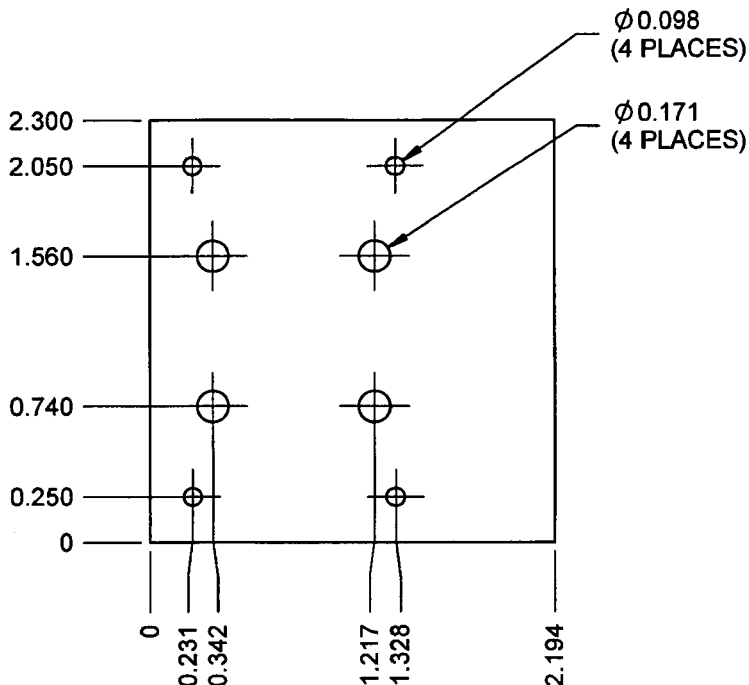
Job Completion



MF 09-02-19

DART

DESIGN BW	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED [Signature]	DRAWING NO. D2151	REV. B SHEET 1 OF 1
DATE 06.10.13		TITLE PACKER	SCALE 1:1
REV	DATE	DESCRIPTION	
A	95.05.01	NEW ISSUE	
B	06.10.13	UPDATE DRAWING	

RELEASED06.11.20 **[Signature]****D2151 PACKER**

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
W4889

NOTES:

- 1) MATERIAL: ALUMINUM 2024-T3 SHEET 0.040 THICK PER QQ-A-250/4 OR AMS 4037 (REF DART SPEC M2024T3S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE GLOSS (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) IDENTIFY WITH DART P/N "D2151" USING FINE POINT PERMANENT INK MARKER

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